

Work Order ID 115957

April-07-14 9:17:38 AM

\*115957\*

Page 1

Item ID: D4806-3

Revision ID:

Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00 \*1\*

Required Date: 04/04/2014 Req'd Qty: 1.00 \*1\*

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MUS Date: 14-04-04

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4806	<u>Rev A Top</u>								
100	DOOSAN LATHE	0.00							
*100*									
Doosan	Memo	0.00							
Doosan Lathe	1- Turn as per Folio FB276 Rev: <u>11/1</u> & Dwg D4806 Rev: <u>4</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

DAS 25 9-89  
DAS 25 9-89

14/04/07

DAS 25 9-89  
14-4-8

*[Signature]*

7-28  
53  
DAS

7-28  
53  
DAS

Work Order ID 115957

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\*115957\*

Page 2

Item ID: D4806-3

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Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00 \*1\*

Required Date: 04/04/2014 Req'd Qty: 1.00 \*1\*

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

Quality Control

0.00

14/03/08

2

0

DAS  
14  
9-89

130

Outsource process - NDT per QSI038 4.1

0.00

\*130\*

Outsource2

Memo

Outsource process - NDT

ISSUE P/O: 23701

C OF C IS REQUIRED

0.00

CX 14/04/08 (2)

140

Receive & Inspect for Damage & Mat'l Certs

0.00

\*140\*

Packaging

Memo

Packaging

0.00

14/4/8 (2)



240  
47  
29-6

# Work Order ID 115957

April-07-14 9:17:38 AM

\*115957\*

Page 3

Item ID: D4806-3

Revision ID:

Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00 \*1\*

Required Date: 04/04/2014 Req'd Qty: 1.00 \*1\*

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

27  
9-89

\*150\*

QC

Memo

0.00

14/4/9

2

Quality Control

160

Identify as per dwg & Stock Location: St 123

0.00

\*160\*

Packaging

Memo

0.00

DAS  
33  
9-89

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

MCS 1404-11

Quality Control

WF  
14-4-10





# Picklist Print

Page 1

April 07-14 9:17:37 AM

Work Order ID: 115957

\*115957\*

Parent Item: D4806-3

\*D4806-3\*

Parent Item Name: Stud

Start Date: 04/04/2014

Required Date: 04/04/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174PH-H900R0.625

Purchased

No

f

5.5000

1

\*M174PH-H900R0 625\*

\*\*

SL 14-4-8

17-4 SS H900 ROUND BAR 0.625

Location

Loc Qty

Loc Code

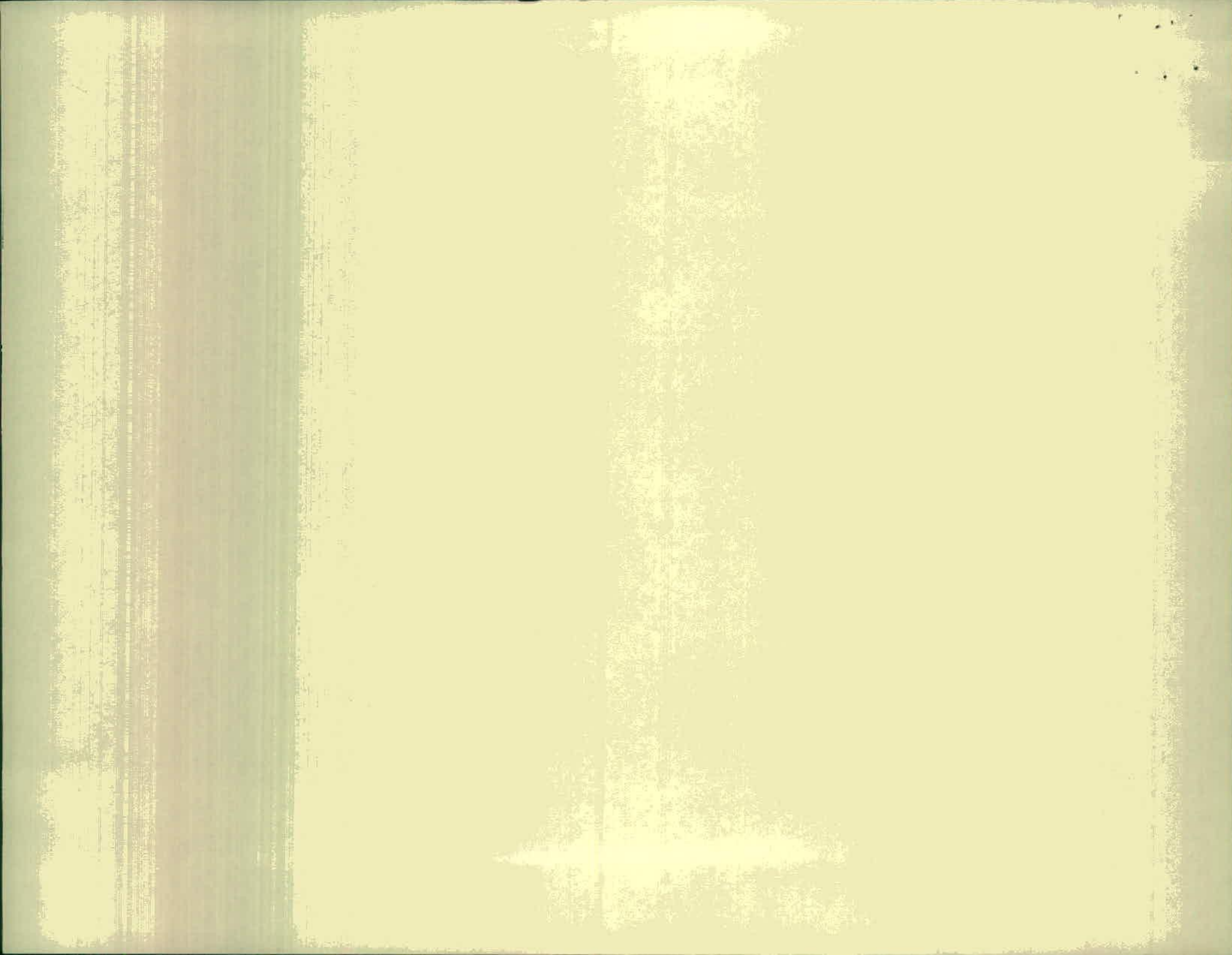
MAT031

5.5

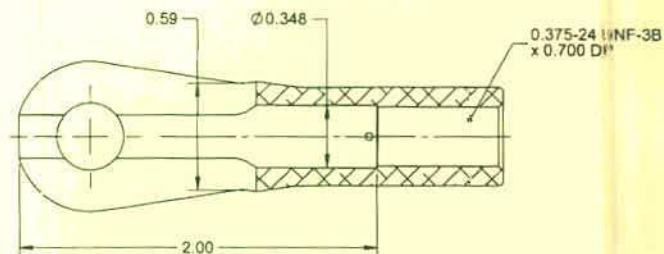
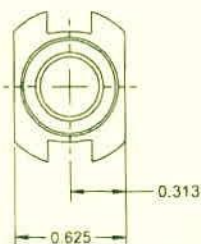
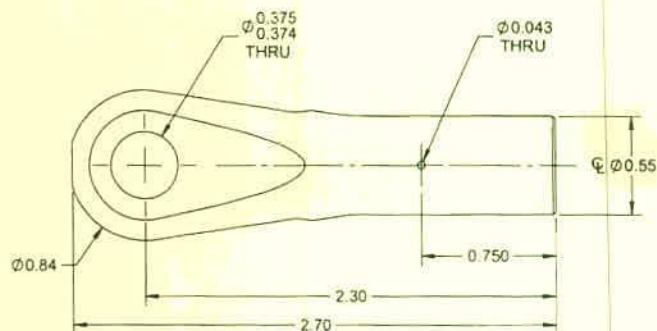
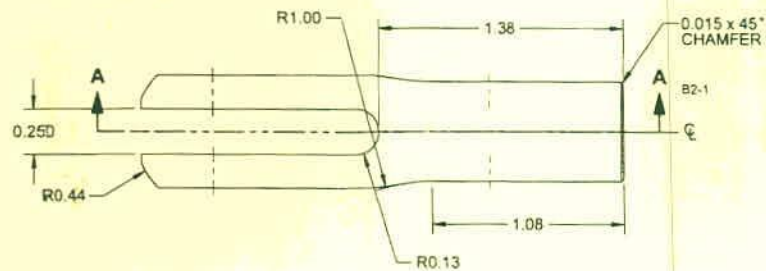
⌘ M127334

5.5

55







SECTION A-A D5-1

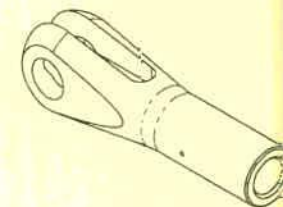
**D4806-1 CLEVIS**

**NOTES:**

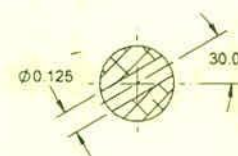
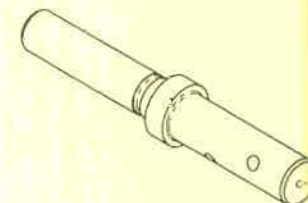
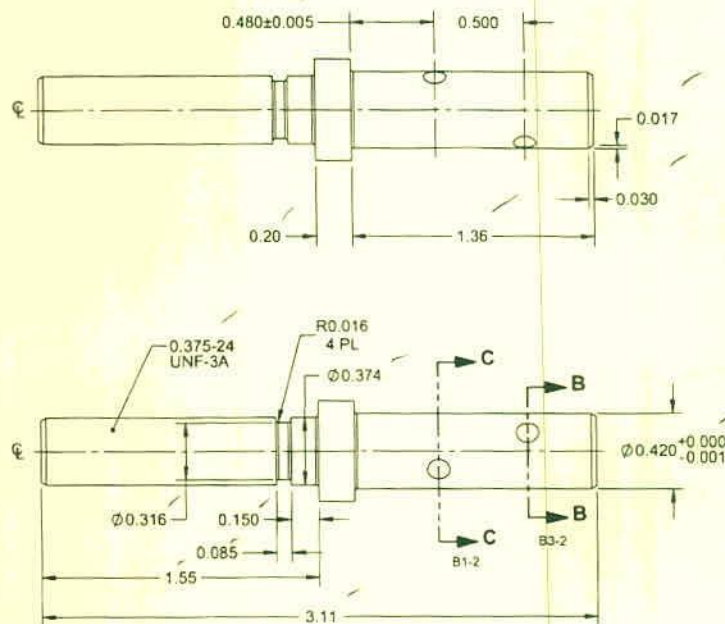
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

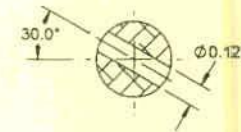
A NEW ISSUE		RF	13.09.18
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR	JLM	D4806	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR	DS	END FITTING	N/A
DATE	13.12.18	<small>CONFIDENTIAL © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







SECTION B-B C5-2



SECTION C-C C5-2

# **D4806-3 STUD**

## **NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.11 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV: A
MFG. APPR.	JLM	<b>D4806</b>	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>END FITTING</b>	MFS
DATE	13.12.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE ASSUMPTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





## Jean-Luc Menard

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**From:** Roberto Fuentes  
**Sent:** April-07 14 11:13 AM  
**To:** Jean-Luc Menard; Harvey Siemens  
**Subject:** acceptable to add center drill hole to D4806-3

Hi JL,

Per ours conversation this morning, it is acceptable to add (ref. #3) center drill hole to D4806-3 Stud at end of the thread section.

Roberto





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 115957
<b>Description:</b>		<b>Part Number:</b> D4806-3
<b>Inspection Dwg:</b> D4806	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.480	+ .005	.479	/		UG	
.500	+ .010	.501	/			
.017	+ .010	.020	/		Vern	SL-10
.030	+ .010	.030	/		-	
1.36	+ .030	1.358	/		-	
.20	+ .030	.202	/		-	
.56	+ .030	.560	/		-	
Ø.125	+ .004 - .001	.126	/		-	
3/8-24 UNF-3A		/	/			
.374	+ .010	.373	/		-	
.420	+ .001	.4195	/		mic	SL-4
3.11	+ .030	3.112	/			
1.55	+ .030	1.550	/			
.085	+ .010	.083	/			
.150	+ .010	.150	/			
.316	+ .010	.317	/			

DAS  
14  
9-89

<b>Measured by:</b> SL	<b>Audited by:</b>	<b>Preliminary Approval:</b>
<b>Date:</b> 14-4-8	<b>Date:</b> 14/04/08	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15





**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20484	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23701
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: <b>UNSCHEDULED</b>			Sequence: 1

**Work Required:**

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 23 MISC PARTS

ITEM ID: E4702-041 LADDER ASSY

1 - WORK ORDER ID#: 111875 (QTY5)

ITEM ID: E4706-041 SUPPORT ASSY

2 - WORK ORDER ID#: 111856 (QTY5)

ITEM ID: D4806-3 STUD

3 - WORK ORDER ID#: 115957 (QTY4)

ID#: D4807-041 SUPPORT ASSY

4 - WORK ORDER ID#: 111664 (QTY3)

ID#: D4882-1 STRUT

5 - WORK ORDER ID#: 115543 (QTY4)

ID#: D4883-1 END FITTING

6 - WORK ORDER ID#: 113533 (QTY4)

<b>Action Taken:</b>		<b>Date:</b>	<b>Initial/Stamp:</b>		
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-6) AS PER ASTM1417M-13		APR 08 2014	<div>DOT APP 177 53-89</div>		
NO CRACK FOUND					
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018					
Description	Location P/N	Qty	Batch	S/N Off	S/N On

Certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness

Signature:	ACA/SCA Stamp <div>DOT APP 177 53-89</div>	Date: APR 08 2014
Name: <b>ANTONINO MARCHETTA</b>		



